

**Work Order ID 67718**

Tuesday, March 29, 2011 1:32:29 PM

ASAP



Page 1

Item ID: D3208-11

Accept



Setup Start



Revision ID:

Item Name: Filler

Stop



Start Date: 3/29/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

✓

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3208	Rev A1

100



FLOW WATER JET

Waterjet

Memo

0.00

FBII-3-29

FLOW CNC Waterjet

2024.040

I-Cut as per Dwg D3208 i Dwg Rev: A1 i Prog Rev: A1 i 2-  
Deburr if necessary

(IS)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

FBII-3-29

Memo

0.00

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

Sulog 1/29

+(1)

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Page 2

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Start



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Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



HandFinish

Operation  
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

15. BL 11-3-30.

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

15 of all 100

150



Packaging

Packaging

Identify as per dwg &amp; Stock Location:

ZOC

0.00

Memo

0.00

11/3/30 15x8

# Work Order ID 67718

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Page 3

Item ID: D3208-11

Accept



Setup Start



Revision ID:

Item Name: Filler

Stop



Start Date: 3/29/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11/3/31 JF

MF

11-03-30

# Picklist Print

Tuesday, March 29, 2011 1:32:27 PM

Page 1

Work Order ID: 67718



Parent Item: D3208-11



Parent Item Name: Filler

Start Date: 3/29/2011

Required Date: 3/30/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: A 04.06.09! New issue! KJ/RF!

IPP B 08.11.17 Waterjet EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	139.0000	0.1646	1.732632	2.5		

2024-T3 .040 sheet



Location	Loc Qty	Loc Code
MAT022	139	
112291	5	
112331	64	
113162	70	13162

(K)

DART AEROSPACE LTD	Work Order:	67718
Description: Filler	Part Number:	D3208-11
Inspection Dwg: D3208	Rev: A1	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>RB</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	14-3-29	Date:	11/03/29	Date:	N/A

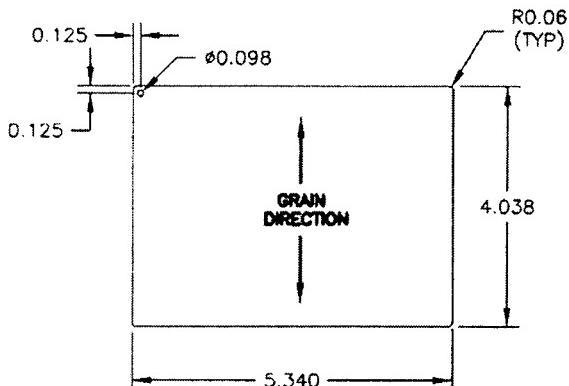
Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	SJL



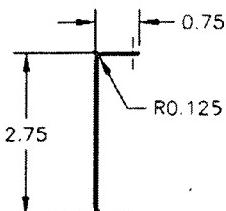
DESIGN KT	DRAWN BY KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3

RELEASED  
04.04.03

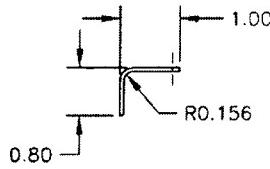
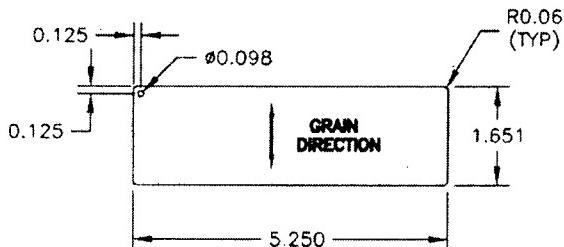
100-0125-A1-A1-D3208-1



2 D3208-1 DOUBLER  
FLAT PATTERN



D3208-1 DOUBLER  
BEND DETAIL



D3208-3 PEDAL MOUNT ANGLE  
BEND DETAIL

NOTES:

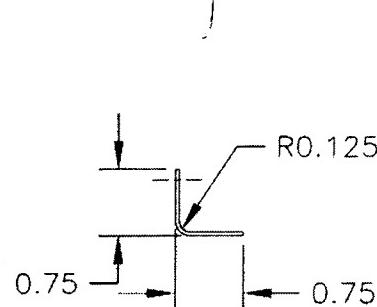
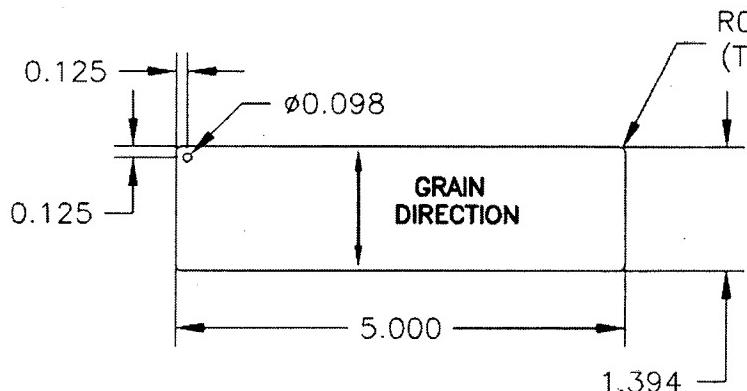
- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

Wb 6778



DESIGN <i>H</i>	DRAWN BY <i>H</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3208	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

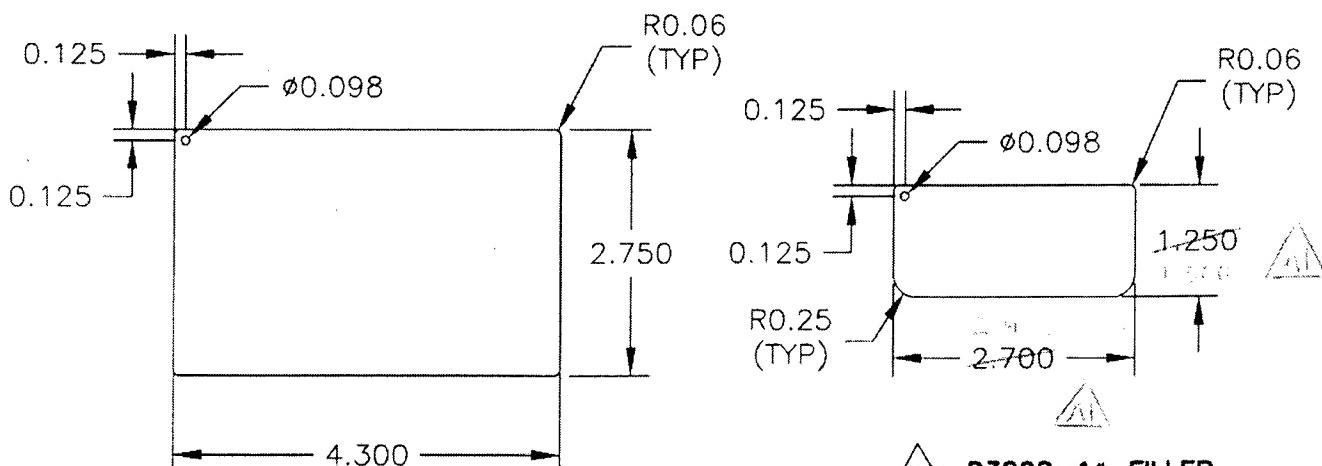
RELEASED  
04.04.05 *H*



D3208-5 MOUNT ANGLE  
BEND DETAIL



D3208-5 MOUNT ANGLE  
FLAT PATTERN



D3208-11 FILLER



D3208-7 FILLER

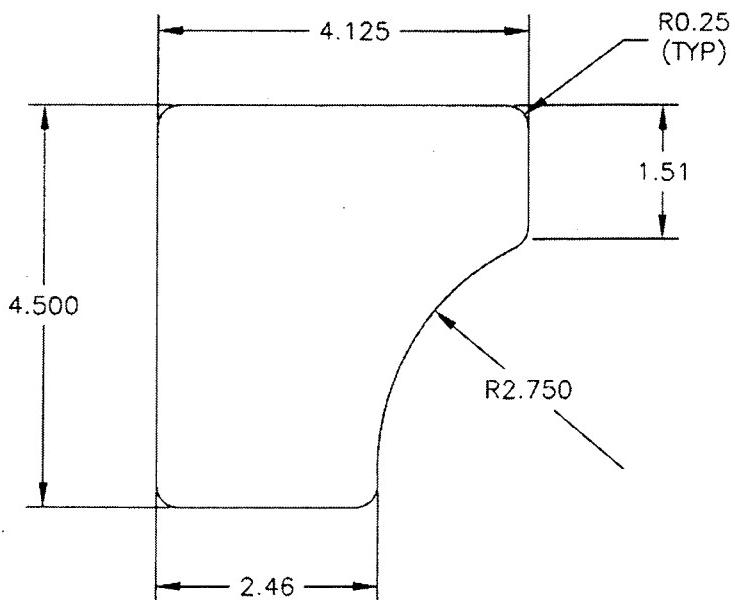
*(AFH)*

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**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3208	SHEET 3 OF 3
DATE	TITLE	SCALE	
04.01.27	DOUBLER	1:2	

**RELEASED**  
24-Nov-05**D3208-9 DOUBLER**

67718

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